

Work Order ID 63216

Monday, October 25, 2010 12:35:23 PM

Page 1

Item ID: D212-725-1-097

Accept

Setup Start

Revision ID:

Item Name: Packer

Stop

Start Date: 10/25/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

G

100

0.00



Waterjet

FLOW CNC Waterjet

6061 .375x3"

Memo

1-Cut as per Dwg

Dwg Rev: G

Prog Rev: G

2-Deburr if necessary

0.00

10-10-27

4

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/10/28

(XU)

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 BK 10/10/28

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Cape (4)

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Accept



Setup Start



Revision ID:

Stop



Item Name: Packer

Start Date: 10/25/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

383

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/28
4

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 63216



Parent Item: D212-725-1-097



Parent Item Name: Packer

Start Date: 10/25/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B0.375X03.00
0

Purchased

No

100

f

13.6000

0.0194

0.081684



R310-10-27

6061T6 BAR .375 X 3.00

Location

Loc Qty

Loc Code

MAT02

13.6

18237

13.6

18237

④

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DDID-725-1-097

<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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Measured by: <u>IB</u>	Audited by: <u>S</u>	Prototype Approval:
Date: <u>10-10-27</u>	Date: <u>10/10/28</u>	Date:

H:\FORMS\Quality Assurance\approved QA\FAI revD

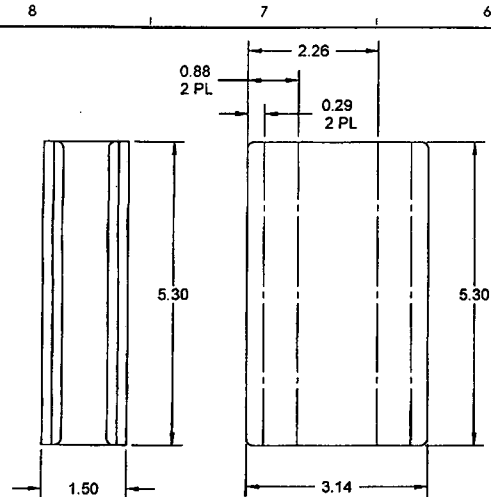
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

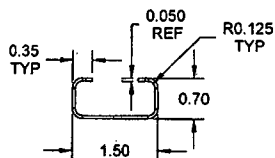
WORK ORDER

NO. 63216

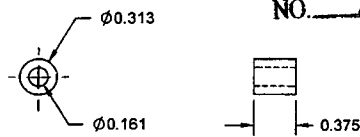
BL10-10-25



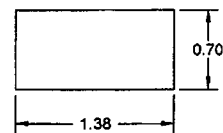
D212-725-1-081F FLAT PATTERN



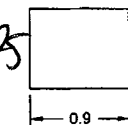
D212-725-1-081 SUPPORT
(MAKE FROM D212-725-1-081F FLAT PATTERN)



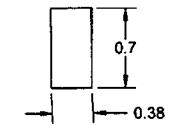
D212-725-1-101 SPACER



D212-725-1-095 RADIUS BLOCK



D212-725-1-097 PACKER



D212-725-1-099 RADIUS BLOCK

D212-725-1-095/097/099 NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF DART SPEC. M6061T6B
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

D212-725-1-101 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR ASTM B211 OR ASTM B221
REF DART SPEC. M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

D212-725-1-081 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED, 2B FINISH 0.050 (18 GAUGE) THICK
PER AMS-5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S18GA
- 2) FINISH: NONE

GENERAL NOTES:

- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

RELEASED

10.02.71

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<u>160</u>	DRAWING NO.	REV. G
MFG. APPR.	<u>160</u>	D212-725-1	SHEET 31 OF 84
APPROVED	<u>160</u>	TITLE	SCALE
DE APPR.	<u>160</u>	212S DETAIL PARTS	NTS
DATE	10.02.12	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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